

Work Order ID 50315

July 14, 2009 2:45:13 PM



Page 1

Item ID: D3120-3

GJ

Accept



Setup Start



Revision ID: B

Item Name: Cover

Stop



Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00



Customer:

Reference:Approvals: Process Plan: *CJC 9/10/09* Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp****Draw Nbr****Revision Nbr**

D3120

Rev B

110



HAAS CNC VERTICAL MACHINING #1

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3120

Prog rev: *B*Dwg rev: *B*

Deburr as required

PB 9-8-12

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

PB 9-8-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3120-3

D412-6941-03
-00

PAR #: _____

Fault Category: Small/Med Fats

NCR: Yes

No DQA: *J*

Date: 05/05/25

Scrap / Scrap.

QA: N/C Closed: *J*

Date: 05/05/25

NCR: 50315

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/05/14	135	I part is scrap because piece broke (the tab) R.C: process/ thin mat'l	<i>J</i> ensure	Scrap & destroy No replace Ensure deburring is completed.	S8 09/05/14	<i>J</i>	<i>J</i>	<i>J</i>

NOTE: Date & initial all entries

Work Order ID 50315

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Item ID: D3120-3

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Memo

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00
BK 09/09-18
0.00

① -

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

9/9/18 ④ SP

Memo

0.00

180



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

09/09/18 JJ
MF 09-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 50315



Parent Item: D3120-3RevB



Parent Item Name: Cover

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	111.0100	0.4587	(2)		

2024-T3 .032 sheet



Warehouse

Location

Main Warehouse

MAT	Loc Qty	Loc Code
102942	1.5	
105555	5	
106272	8.47	
108595	3	
109240	7.02	
110778	34.02	
111699	49	111699
18147	3	

B 9-8-12

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	SL315
Description: COVER	Part Number:	D3120-3
Inspection Dwg: D3120-4 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

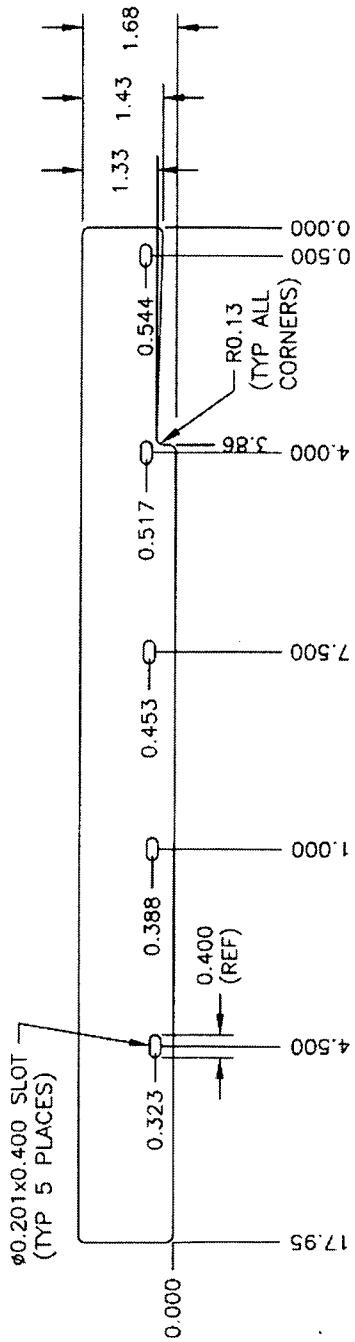
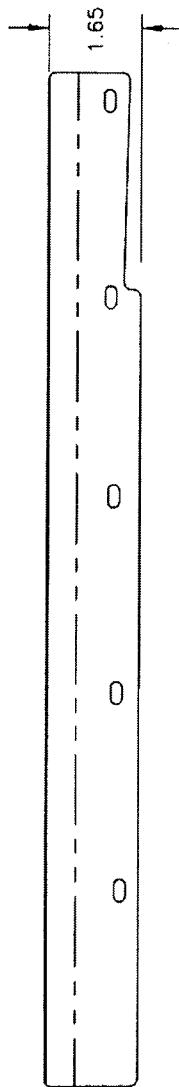
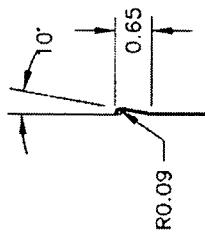
X First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 9-8-12	Date: 09/08/13	Date: 1/19

Rev	Date	Change	Revised by	Approved
A	..	New Issue	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3120	SHEET 1 OF 2
DATE		TITLE	SCALE
04.10.18		COVER	NTS
A	02.04.15	NEW ISSUE	
B	04.10.18	ADD PART MARKING	



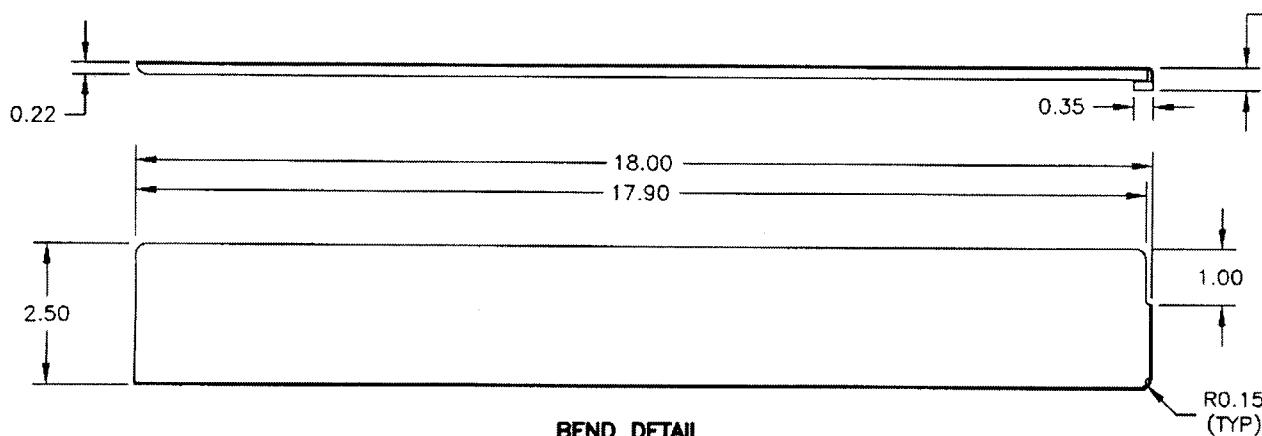
D3120-1/-2 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024TS.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

CO 09/07/14
W/0 : 50315

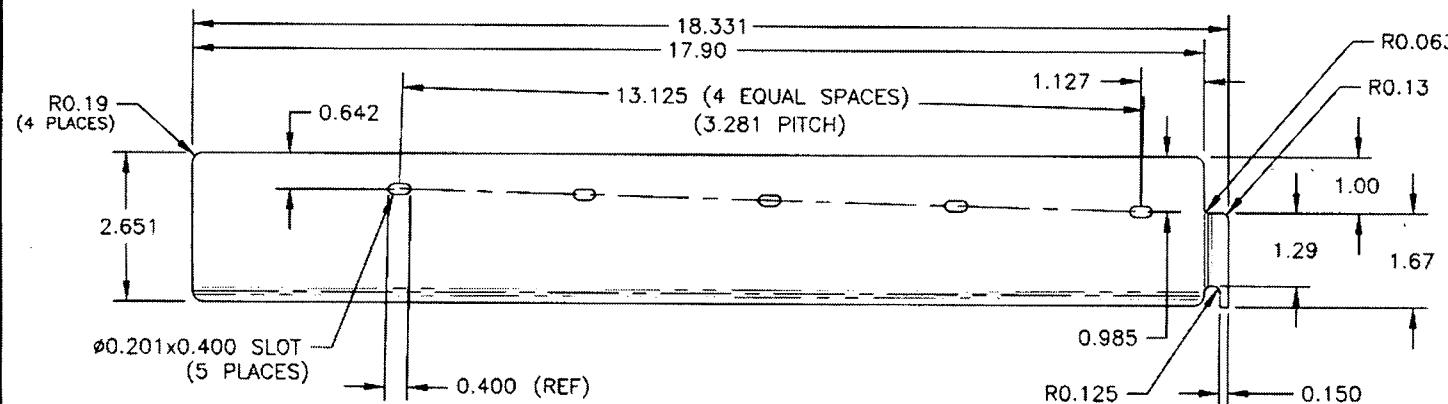
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BEND DETAIL

D3120-3 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-231)
D3120-4 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-232)



D3120-3/-4 COVER, FLAT PATTERN

D3120-3/-4 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

50315

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		DRAWING NO.
		D3120
DATE	TITLE	REV. B
04.10.18	COVER	SHEET 2 OF 2
		SCALE
		NTS